

009066



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D3172-041
Job Sheet 192457



Part No: D3172-041

Job Qty: 1 pcs

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D 11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	5/10/19		0.00	25.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-80
							Large Fab - 8		
110	QC 9	1 pcs	5/10/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	1	5/10/19		0.00	0.00	QC 9 - 9		19.04.13
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		19.04.13



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Container No: S170231



Part: D3172-041

Job No: 192457

Serial No/Batch: S170231

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/07/19

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				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Handfinish - 2-1 Pressure- B4B	1 pcs	5/10/19	0.00 0.38	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	DR 19/04/17
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
140 Powdercoat - 1 White Gl(A)- B4B	1 pcs	5/10/19	0.00 1.04	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	BL 19-4-17
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	HL 19-4-29
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 -	

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				B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	1	5/10/19	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	9-38
				QC 21 - SA - 53	ADD 29 2019

Part Op 100 - (Fabricate per Drwg) 1-Cut Qty 4 D3166-1 as per Drwg D3172 2-Cut 3/4" x 3/4" square tubing as per Drwg D3172 3-Descriptions: Drill holes in D3172-3 as per Drwg D3172 4-Deburr & Remove all markings from material 5-Weld all ribs as per Drwg D3172 using Welding Table 6- Weld top D3174-1 ONLY bottom ones will be welded after mesh is install as per drwg 7-Weld D5365-1 as per drwg in (2) locations. From edge of back basket corn (without hinge) to bottom of D5365-1 lug. And (2) located at the front. 8- Weld mesh as per drwg 9- Use DT10465 jig to locate the bottom D3174-1 as per drwg

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - QC5- Inspect part completeness to step on W/O

130 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)COAT: START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____ 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

145 - Identify as per drwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2232-3 ✓	Basket Hinge	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5 101748
D2327-3 ✓	Spacer Bushing	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5 079118
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5 155219
D3166-1 ✓	Basket Hoop	4 pcs (4 ea) ✓	100-Large Fab - Welded Assy-1	5 152481
D3174-1 ✓	Mounting Lug	8 pcs (8 ea) ✓	100-Large Fab - Welded Assy-1	5 071079
D5365-1 ✓	Lug	4 pcs (4 ea) ✓	100-Large Fab - Welded Assy-1	5 080536
M304EX0.75-16F ✓	Expanded Metal Flat SS	32 sf (32 ea) ✓	100-Large Fab - Welded Assy-1	5 147379
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	51 ft (51 ea)	100-Large Fab - Welded Assy-1	5 155739

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2232-3	2	6	0
	D2327-3	2	20	0
	D2581	2	79	0
	D3166-1	4	17	0
	D3174-1	8	31	0
	D5365-1	4	4	0
	M304EX0.75-16F	32	1,177	0
	M304TS0.750W.065	51	634	0

Part Specifications

Specifications could not be found.

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								